



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T102146-101
Job Sheet 196665



Part No: RB T102146-101

Job Qty: 2 pcs

Part Name: Plate Set



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/18/19

Job Tracking No:

Due Date: 7/30/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RB T102146-101 Rev 0 IPP Rev A 18.03.09 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs	7/30/19		0.00	0.00	Purchasing - 1		DP JUL 02 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	2 pcs	7/30/19		0.00	0.00	Packaging 2 - 1 - B4B		DP JUL 02 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Container No: S195135



Part: RB T102146 - 101

Job No: 196665

Serial No/Batch: S195135

Revision: 0

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/02/19

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120	QC 6	2 pcs	7/30/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
125	Small Fab - 2 - B4B	2 pcs	7/30/19	0.00 2.00	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
126	QC 5	2 pcs	7/30/19	0.00 2.00	QC 5 - 40	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
130	Packaging 3-1 - Stock - B4B	2 pcs	7/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	

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					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - FG	2 pcs	7/30/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	DAS 21 JUL 03 2019
					QC 21 - SA - 53	

Part Op **100** - (Purchasing) - Issue P/O: _____ MANUFACTURE RB T102146-101 AS PER DWG Supplier: ~~AIRCRAFT~~

Descriptions: ~~HARDWARE ACCESS~~ - Certificate of conformity is required

110 - Receive & Inspect for Damage & Mat'l Certs

120 - QC6- All purchased or subcontracted products

~~**125** - Re-identify as required.~~ *Plexus*

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Arrow tech.

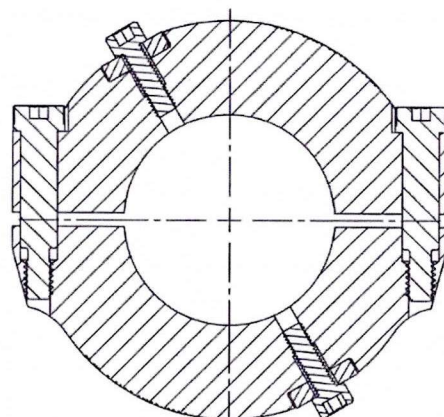
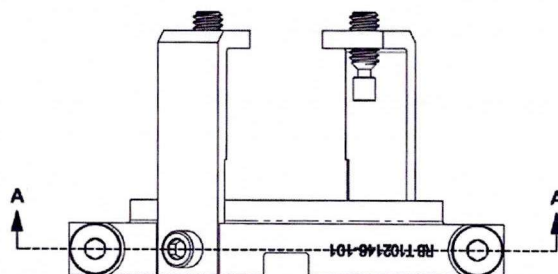
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RB T102146-101P	PLATE SET ASSY	2 pcs (1 ea)	100-Purchasing	<i>5195134</i>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB T102146-101P	2	0	0

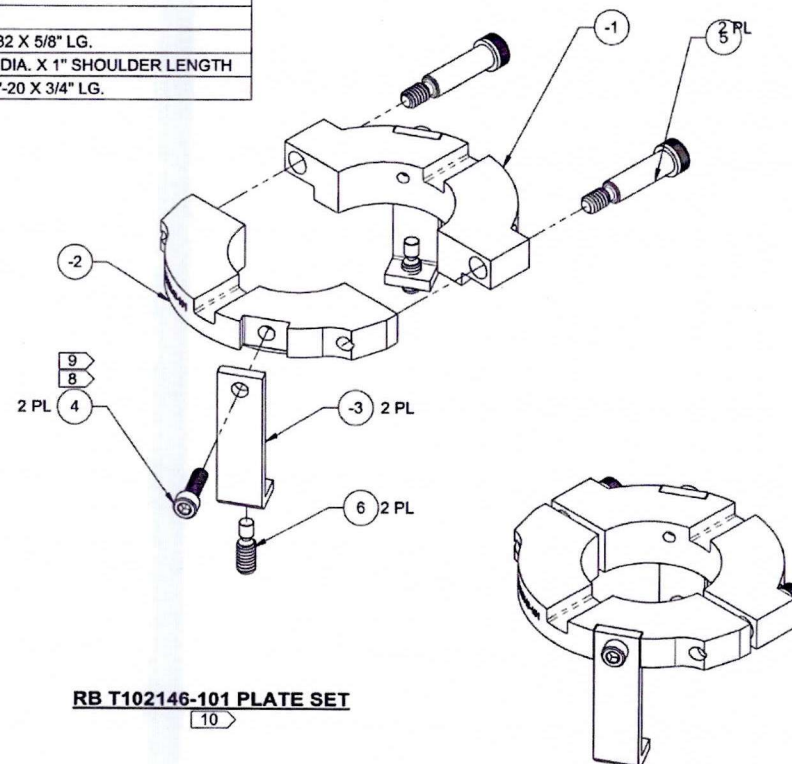
Part Specifications	
Specifications could not be found.	

Plex 6/18/19 1:29 PM dart.lussier.patrick

ITEM #	QTY	PART #	PART TITLE
-1	1	RB T102146-101-1	HALF PLATE 1
-2	1	RB T102146-101-2	HALF PLATE 2
-3	2	RB T102146-101-3	CLIP
4	2	McMaster#91251A344 OR EQUIV.	BLACK OXIDE STEEL SOCKET HEAD SCREW #10-32 X 5/8" LG.
5	2	McMaster#91259A583 OR EQUIV	BLACK OXIDE STEEL SHOULDER SCREW 1/4"-20 X 5/16" SHOULDER DIA. X 1" SHOULDER LENGTH
6	2	CL-2-SSC OR EQUIV	CAD PLATE STEEL 20° SWIVEL SCREW CLAMPS 1/4"-20 X 3/4" LG.



SECTION A-A



NOTES:

1) MATERIAL: N/A
2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

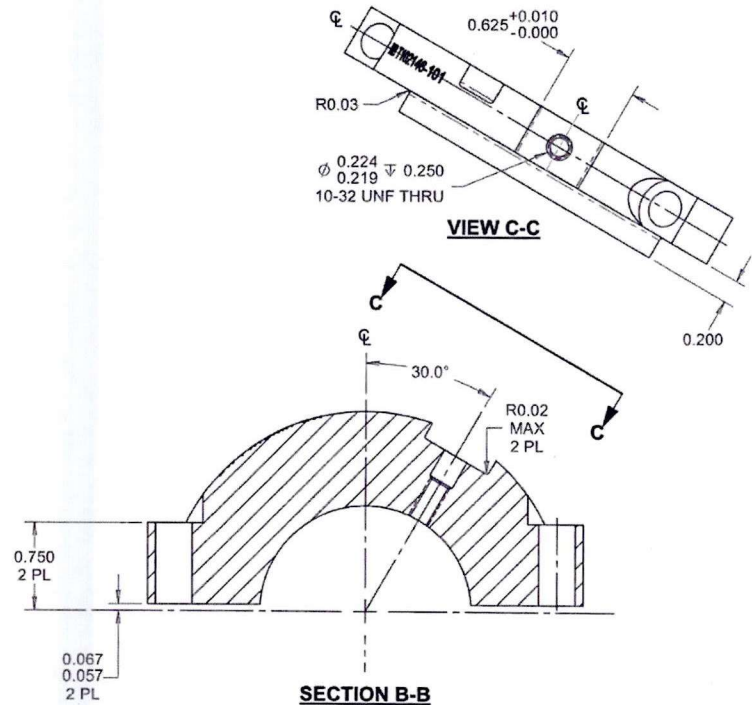
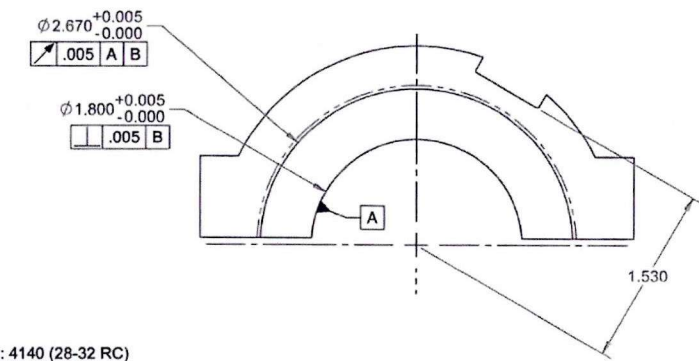
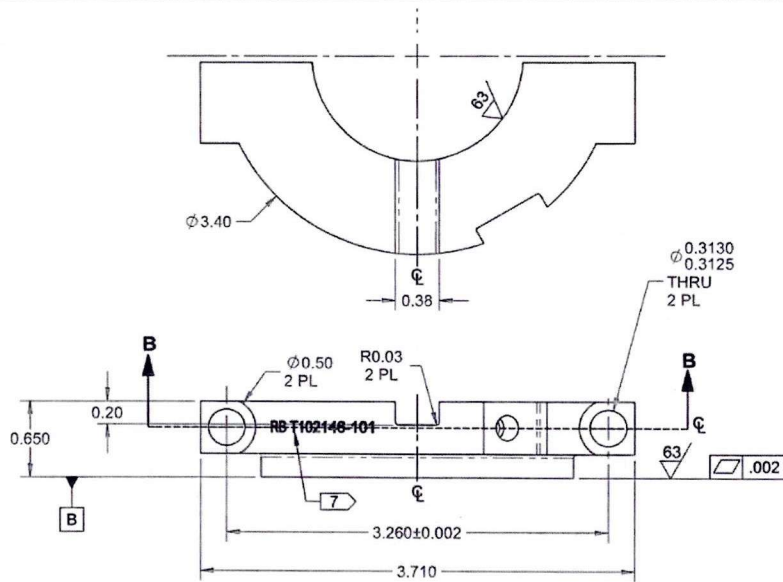
8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 4 THEN ASSEMBLE WITH ITEM -1 AND ITEM -2, AND REMOVE EXCESS

9) INSTALL ITEM 4 HAND TIGHT

10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

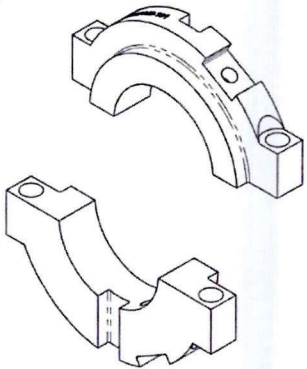
A	FOR OLDER REV SEE PREVIOUS PDF ALL PREVIOUS PART NUMBERS HAVE BEEN REVISED	19-723	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RB T102146-101 TITLE PLATE SET SCALE NTS	
DRAWN	VM		
CHECKED	KPT		
MFG. APPR.	JFC		
APPROVED	<i>[Signature]</i>		
DATE	2019-05-09	REV. A SHEET 1 OF 4 COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



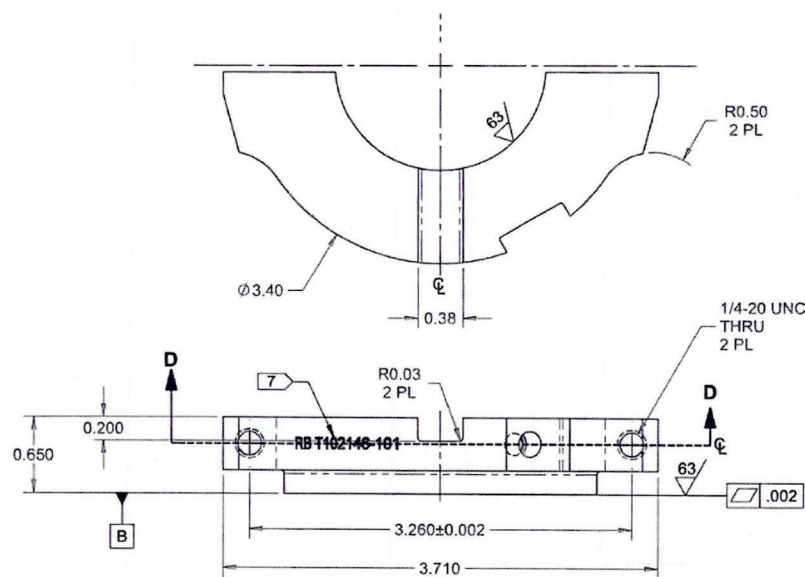
RB T102146-101-1 HALF PLATE 1

- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RB T102146-101", AS SHOWN



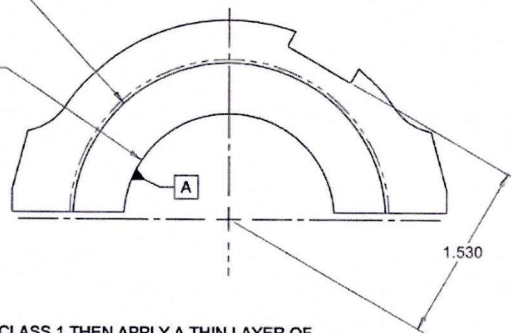
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RB T102146-101	SHEET 2 OF 4
APPROVED		TITLE	SCALE
		PLATE SET	NTS 
DATE	2019-05-09	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



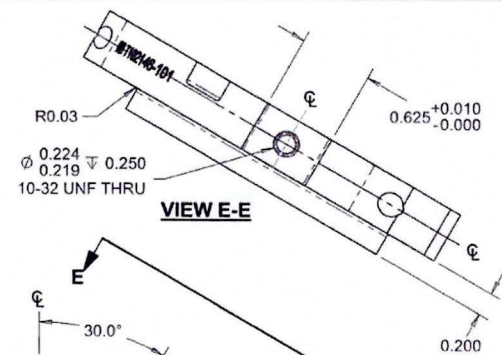
$\phi 2.670^{+0.005}_{-0.000}$
A B
|.005|

$\phi 1.800^{+0.005}_{-0.000}$
B
|.005|

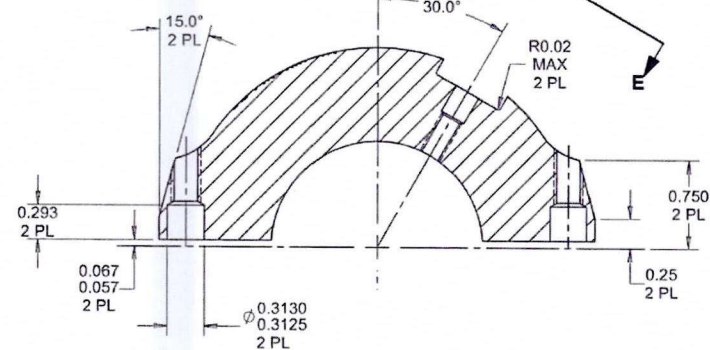


NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RB T102146-101", AS SHOWN



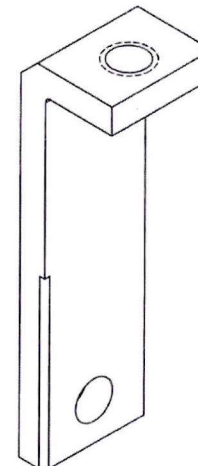
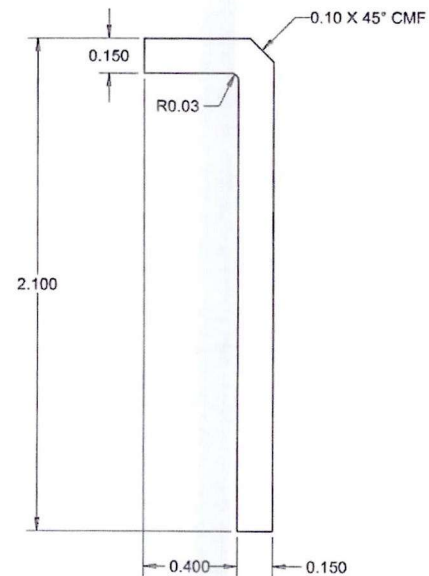
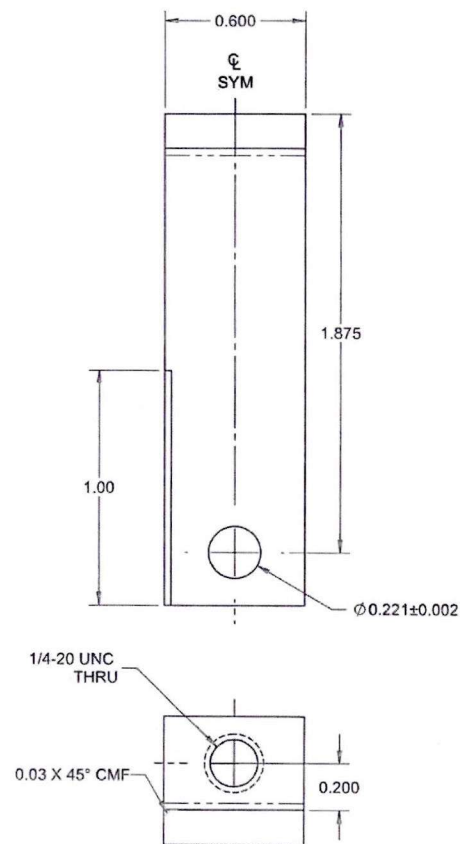
VIEW E-E



SECTION D-D

RB T102146-101-2 HALF PLATE 2

DESIGN	VM	DART AEROSPACE LTD		
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA		
CHECKED	KPT	TOOL PART #		REV. A
MFG. APPR.	JFC	RB T102146-101		SHEET 3 OF 4
APPROVED		TITLE		SCALE
		PLATE SET		NTS 
DATE	2019-05-09	COPYRIGHT © 2019 BY DART AEROSPACE LTD		
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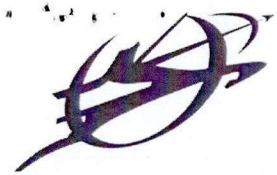


RB T102146-101-3 CLIP

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = ± 0.1 / ± 1
 X.XX = ± 0.01 / ± 0.5
 X.XXX = ± 0.005 / ± 0.1
 X.XXXX = ± 0.0005 / ± 0.05
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RB T102146-101	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
		PLATE SET	NTS
DATE	2019-05-09	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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Quotation

PHGE Machine Works LLC dba
Arrow Tech Machine Works
29751 E. Enid Rd. Unit C
Eugene, Oregon 97402

Date	Quote #
6/18/2019	314

Phc (541) 780-6938
FA (458) 215-4938
Em atechmachineworks@gmail.com

Customer Details	Payment Terms	Sales Rep
DartAerospace	Withing 30 days due net	Gabriel Escobar
	Contact	
	Patrick Lussier	

Qty	Item	Description	Unit Price	Amount
2	RBT102146-101 REV-A	Plate Set	\$ 1,195.00	\$ 2,390.00

Thank You

Subtotal	\$	2,390.00
Freight		
Payment and Credit Applied		
Total	<u>\$</u>	<u>2,390.00</u>



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043776



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB043776

PO Date: 6/18/19

Due Date: 7/30/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	196665	RB T102146-101P			PLATE SET ASSY As Per Dwg T102146-101	Firmed	-	7/30/19	2 pcs	0 pcs	2 pcs	\$1,195.00/pcs	\$2,390.00

JUL 02 2019

Grand Total: \$2,390.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

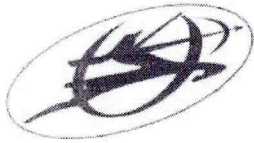
A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

[Signature]

Plex 6/19/19 9:29 AM dart.lussier.patrick

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**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 608

Date: 7/1/2019
PO Ref: HB043776
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty
2

Item
PLATE SET ASSEMBLY

Part No.
RB T102146-101 REV A

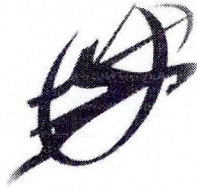
RECEIVED
JUL 02 2019
DART AEROSPACE LTD.

Received by:

Packaged by: *JML*

Checked by: *AMP*

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB043776

Dated: 7/1/2019

Our Order / Job No: HB043776-1AWT

Order Qty: 2

Part Name: PLATE SET ASSEMBLY

Part Number RB T102146-101

Lot Size: N/A Ship Date: 7/1/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB T102146-101 Rev: A

Material Size and Type: -1, -2, -3/ 4140 Q&T STEEL

Material Specifications: STEEL: ASTM A108

Heat Treatment: (28.0-32.0 RC)

Plating/Finish: BLACK OXIDE: QMSI-6.2.2 B.O. REV D

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 7/1/19

Signed: Hemat or Fath

DAS
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PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com